

Date: Wednesday, 22/04/2009 1:43:26 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT WALL PROTECTOR
Job Number : 47376	
Estimate Number : 13870	
P.O. Number	Part Number : D39331
This Issue : 22/04/2009 S.O. No. :	Drawing Number : D3933 PROTOTYPE
Prsht Rev. : NC	Project Number : N/A
First Issue : 22/04/2009 Type : SMALL /MED FAB	Drawing Revision : PROTO
Previous Run :	Material :
Written By :	Due Date : 29/04/2009 Qty: 1 Um: Each
Checked & Approved By : <u>22/04/09.22</u>	
Comment : Est Rev:A 09.04.22 new issue EC verified by:DD	

Additional Product

Job Number:



PROTOTYPE
 FOR ENGINEERING USE ONLY

Seq. #:	Machine Or Operation:	Description :
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1.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
-----	------------------	-------------------------



Comment: Qty.: 7.0140 sf(s)/Unit Total : 7.0140 sf(s)

GE PLASTICS LEXAN SHEET 0.125"

Batch: 109455 18 9-4-22

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3933

Dwg Rev: PROTO 18 9-4-22

Prog Rev: TYPE

①

2- Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



18 9-4-22

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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PA 09.05.04

Comment: SECOND CHECK

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Send to Attn: H-Siemens

@ Part Calgary PA 09.04.05

Date: Wednesday, 22/04/2009 1:43:26 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT WALL PROTECTOR

Job Number: 47376

Part Number: D39331

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/05/06 JA

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-05-05
00280A

PROTOTYPE REQUEST FORM

DART Aerospace Ltd.

Product #: D412-760

Job #: 00280

Date: 09.04.21

Product Name: Cabin Floor and Wall Protectors

Requested By: H. Siemens

Design Manager Approval: _____

Quantity	Part Number	Category	Description	Drawing Date	Material Cert Req'd?	Due Date	Comments	Date Completed
1	D3933-1		Aft Wall Protector, LH	09.04.21	Y	ASAP	Part will be used for testing, please supply certification	
1	D3935-1		Pylon Protector, LH	09.04.21	Y	ASAP	Part will be used for testing, please supply certification	
1	D3935-2		Pylon Protector, RH	09.04.21	Y	ASAP	Part will be used for testing, please supply certification	

DART AEROSPACE LTD		Work Order: 47376
Description: AFT WALL PROTECTOR		Part Number: D3933-1
Inspection Dwg: D3933-1 Rev: PROTO TYPE		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

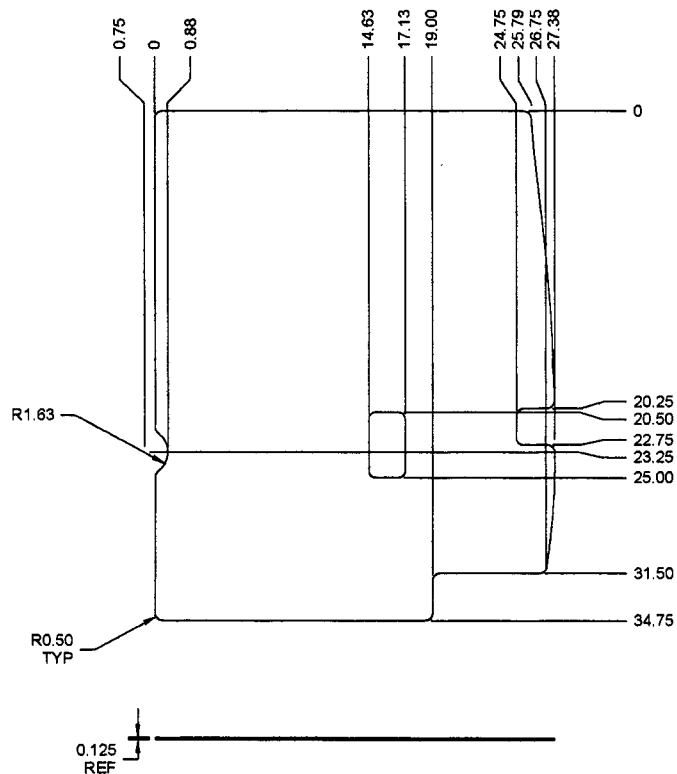
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.25	+/- .030	20.25	X			
20.50	+/- .030	20.50	X			
22.75	+/- .030	22.75	X			
23.25	+/- .030	23.25	X			
25.00	+/- .030	25.00	X			
31.50	+/- .030	31.50	X			
34.75	+/- .030	34.75	X			
.88	+/- .030	.88	X			
14.63	+/- .030	14.63	X			
17.13	+/- .030	17.13	X			
19.00	+/- .030	19.00	X			
24.75	+/- .030	24.75	X			
25.79	+/- .030	25.79	X			
26.75	+/- .030	26.75	X			
27.38	+/- .030	27.38	X			

Measured by: JB	Audited by: PJ	Prototype Approval: PJ
Date: 9-4-07	Date: 09-05-04	Date: 09-05-04

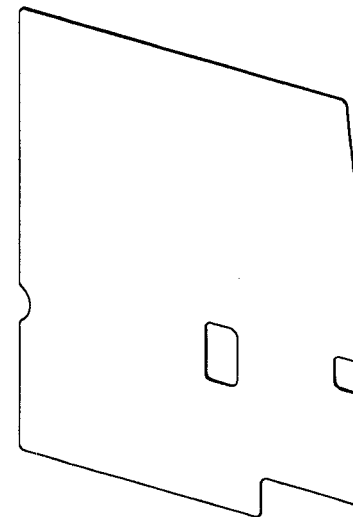
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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D3933-1 AFT CABIN WALL PROTECTOR, LH



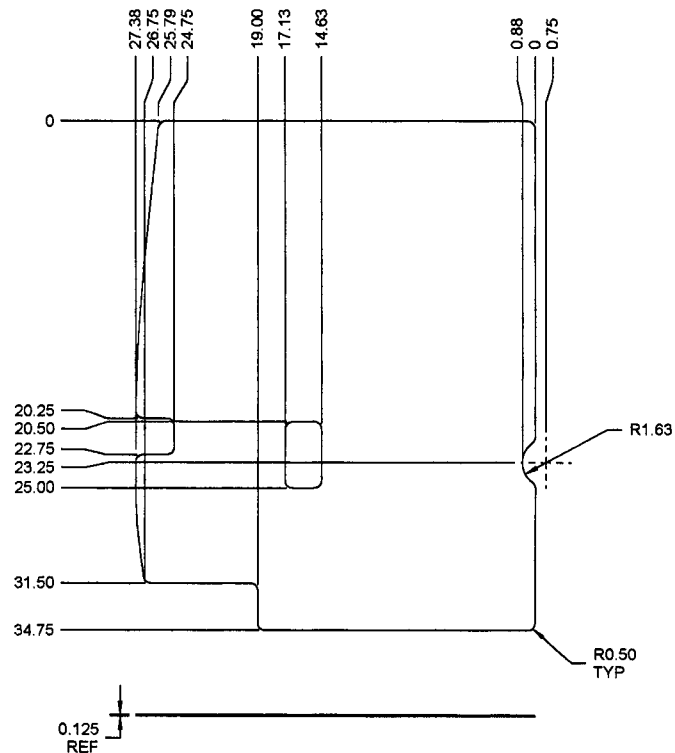
NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3933-1" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 4.84 lbs

A		NEW ISSUE		09.04.21		
REV.		DESCRIPTION		BY	DATE	
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A	SHEET 1 OF 2	
DRAWN						
CHECKED		DRAWING NO. D3933		SCALE	NTS	
MFG. APPR.		TITLE AFT WALL PROTECTOR				
APPROVED		DATE 09.04.21		COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DE APPR.						

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D3933-2 AFT CABIN WALL PROTECTOR, RH

NOTES:

- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125 THICK
TEXTURED SIDE UP (REF DART SPEC MLEXS.125-F60029-04)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3933-2" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH SIDE
- 7) WEIGHT: 4.84 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN		
CHECKED		DRAWING NO. REV. A
MFG. APPR.		D3933 SHEET 2 OF 2
APPROVED		TITLE SCALE
DE APPR.		AFT WALL PROTECTOR NTS
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